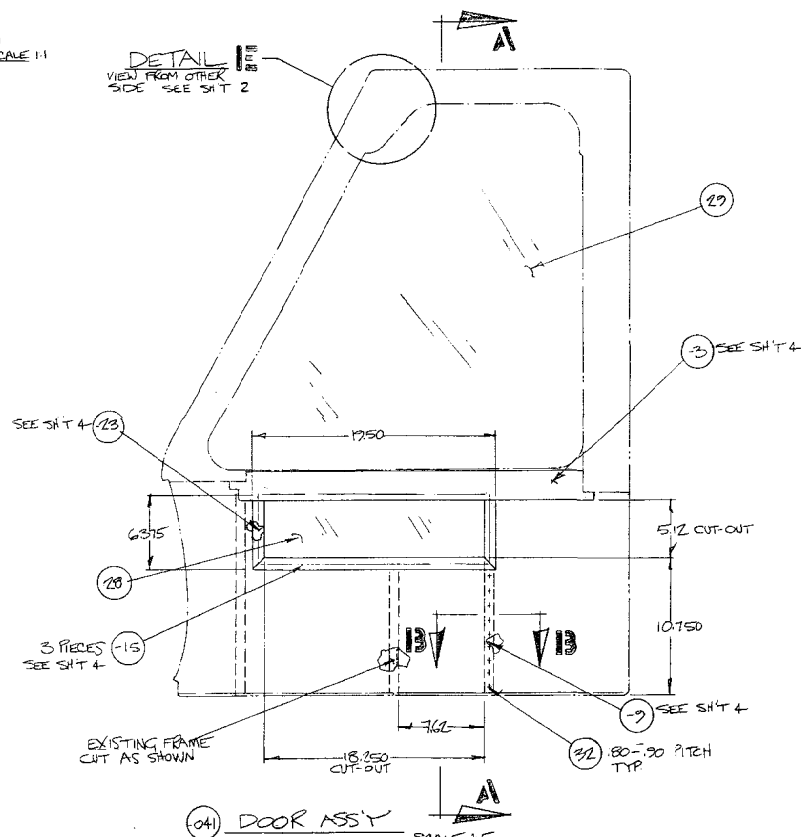


SECTION B-B
SCALE 1:1

DETAIL 1:1
VIEW FROM OTHER
SIDE SEE SH'T 2



041 DOOR ASS'Y
SCALE 1:5

TYPICAL WINDOW
INSTALLATION

NOTES

1. ALL MATERIAL, PARTS & COMPONENTS MUST MEET REQUIREMENTS OF E & I MANUAL PART I, PARAGRAPH 3.1.9.
2. WORKMANSHIP MUST BE TO REQUIREMENTS OF E & I MANUAL AC 43.13.1A & 2A
3. PRIME & PAINT PER AIRCRAFT REQUIREMENTS
4. WELD IN ACCORDANCE WITH MIL-W-8804
5. SEAL BETWEEN WINDOW & DOOR WITH PRO SEAL 890, MIL-S-8802D OR PRC 1521-B2, MIL-S-8784-B
6. BEND RADIUS FOR 2024-T3 :
 .040 THK094 RAD
 .050 THK125 RAD

7. INSTALLATION NOTE:

REMOVE EXISTING WINDOW, FRAME, SLIP-POST & TOP FWD LOCKING MECHANISM WHICH INCLUDES:

- SPRING, 204-050-890-1
- PIN, 204-030-893-1
- PIN, AN 121604
- ROD ASSY DOOR LATCH, 204-050-485-3
- ROD ASSY DOOR LATCH, 204-050-483-1/REMOVE & RE-USE
- ROLLER ASSY DOOR, 204-050-492-1/REMOVE & RE-USE
- NUT, AN 365-632
- WASHER, NAS 1197-6L
- WASHER, NAS 1197-8L
- BOLT, 204-050-861-1
- BELLCRANK, 204-030-482-3
- BUSHING, 22-004810-16-12

REFER TO BELL 204/205/212/2146 ILLUSTRATED PARTS MANUAL, SECTION X AIRFRAME PAGE 10-32

B	MS21081-3	36	ANCHOR NUT		
G	MS24693-548	35	SCREW		
G	NAS 995-17	34	NUT		
30	MS20426AD	33	RIVET		
AK	MS20470AD	32	RIVET		
39	AB-75	31	RIVNUT		OF GOODRICH
39	MS35106-244	30	SCREW		
1	204B-1033-1	29	BUBBLE WINDOW		TECH TOOL
		28	WINDOW	1/2 LEXAN	
1	D204-513	25	ROD MODIFIED BEL PIN 204-030-492-1		
1		23	WEB-FWD 2024-T3 .040 THK		204-A-250/5
1		21	ANGLE-TOP		
AK		19	ANGLE	2024-T3 .040 THK	204-A-250/5
AK		17	ANGLE	2024-T3 .040 THK	204-A-250/11
3		15	RETAINER	2024-T3 .050 THK	204-A-250/11
1		13	GUIDE	6061-T6 .050 THK	204-A-250/11
1	D204-513	11	BRACKET	6061-T6 .050 THK	204-A-250/11
1		9	WEB-APT 2024-T3 .040 THK		204-A-250/5
1		7	ANGLE	.040 THK	
1		5	INST/MNT PANEL	.050 THK	
1		3	PLATE	.050 THK	
1		1	BACK PLATE 2024-T3 .050 THK		204-A-250/5
1		04	DOOR ASS'Y		
1		01	INSTALLATION		
1	D204-513	01	INSTALLATION		

REVISION DRAWN APPROVED DESCRIPTION OF CHANGE		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO SYSTEMS INC. REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL-S-7742 5. HOLES PER MIL-10587 1. TOLERANCES - .001 ± .030 2. ANGLES 3. PARALLELISM 4. PERPENDICULARITY 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		RIVET CODE SHALL BE PER NAS 822 BASIC CODE DIA DASH NO HEAD/NEAR SIDE F/HEAD FAR SIDE D-DIMPLE DISTING OF SHEETS CH/CONTAINER/BANK LENGTH DASH NO W/SPOTWELD BASIC CODES BAW30410AD BBAW30420AD		APPROVAL CONTRACT NO DRAWN DESIGN STRESS CHECKED CLIENT		PART NO DATE CLIENT TITLE D204-513 SCALE AS NOTED SHT 1 OF 4		DART AERO SYSTEMS INC. VANCOUVER CANADA BELL 204/205/212/2146 VERTICAL REFERENCE WINDOW INSTN	
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REPORT ALL DISCREPANCIES - DO NOT SCALE

